

Work Order ID 58235

Friday, April 30, 2010 1:00:35 PM



Page 1

Item ID: D3913-041

Accept



Setup Start



Revision ID:

Item Name: Long Basket Base Assembly, 350

Stop



Start Date: 4/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/7/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 10-4-30

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3913

A

100

Weld per dwg A/R S.S. rod Batch: *H108775* 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D3913

inspect before welding mesh

2- tack weld mesh on basket as per dwg D3913

3- weld hinge (3) and Mounting brackets as per dwg D3913

take lid to locate hinge and bracket

10/05/18 (LX)

PD 10.05.18

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PC 10-05-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID:	D3913-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Long Basket Base Assembly, 350					
Start Date:	4/30/2010	Start Qty:	1.00		Cust Item ID:	
Required Date:	5/7/2010	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							

130 	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
Powdercoat Powder Coating	<p>1114202</p> <p>Memo</p> <p>1- Plug holes and mask only interior of hinge (3) prior to powder coat</p> <p>1ST COAT: START TIME: 1:00pm OVEN TEMPERATURE: 400°F FINISH TIME: 1:20pm ***** 2nd coat if necessary*****</p> <p>2ND COAT: START TIME: 1:45pm OVEN TEMPERATURE: 400°F FINISH TIME: 2:15pm</p>	0.00							

=> MU 10/05/19 1

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Stop



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Start Date: 4/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/7/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

150



Assemble as per dwg

0.00

HandFinish

Memo

0.00

Hand Finishing

Pick Kit

160



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Revision ID:

Stop

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Start Date: 4/30/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 5/7/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: 6-A

0.00

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

EP 5/05/10 @

10/05/2010
MF
10-5-19

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 58235

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/30/2010






Required Date: 5/7/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status															
AN3-10A  Bolt		Purchased	No			150	Each	112.0000	6																		
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST351</td><td>112</td><td></td></tr><tr><td>111119</td><td>12</td><td></td></tr><tr><td>114330</td><td>100</td><td></td></tr><tr><td>114348</td><td></td><td></td></tr></table>													Location	Loc Qty	Loc Code	ST351	112		111119	12		114330	100		114348		
Location	Loc Qty	Loc Code																									
ST351	112																										
111119	12																										
114330	100																										
114348																											
AN960JD8  Washer		Purchased	No			150	Each	0.0000	2																		
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>WA</td><td>27</td><td></td></tr><tr><td>46086</td><td>2</td><td></td></tr><tr><td>51745</td><td>2</td><td></td></tr><tr><td>57185</td><td>23</td><td></td></tr></table>													Location	Loc Qty	Loc Code	WA	27		46086	2		51745	2		57185	23	
Location	Loc Qty	Loc Code																									
WA	27																										
46086	2																										
51745	2																										
57185	23																										
D2581  Mounting Bracket		Manufactured	No			100	Each	27.0000	2																		
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST504</td><td>872</td><td></td></tr><tr><td>46064</td><td>872</td><td></td></tr></table>													Location	Loc Qty	Loc Code	ST504	872		46064	872							
Location	Loc Qty	Loc Code																									
ST504	872																										
46064	872																										
D2931  Bumper		Manufactured	No			150	Each	872.0000	2																		
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST504</td><td>872</td><td></td></tr><tr><td>46064</td><td>872</td><td></td></tr></table>													Location	Loc Qty	Loc Code	ST504	872		46064	872							
Location	Loc Qty	Loc Code																									
ST504	872																										
46064	872																										
D3913-1  Rib		Manufactured	No			100	Each	0.0000	1																		

NAW 1149 DW8325

So 10/05/19

6

2 So 10/05/19

PD 10.05.07

2

So 10/05/19

2

PD 10.05.07
BSB124-10

W/O:		WORK ORDER CHANGES					
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Parent Item: D3913-041



Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/30/2010

Required Date: 5/7/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3913-15 Wide Handle Plate		Manufactured	No			100	Each	2.0000	1		PD 10.05.07	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				WA		2					B58125 ①	
					57079	2						
D3913-3 Rib		Manufactured	No			100	Each	7.0000	1		PD 10.05.07	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				WA		7						
					57609	1						
					58126	6					①	
D3913-7 Rib		Manufactured	No			100	Each	0.0000	2		PD 10.05.07	
D3913-9 Hinge Rib		Manufactured	No			100	Each	1.0000	1		B58127 → ②	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			PD 10.05.07	
				WA		1					B 58123 → ①	
					57610	1						
D3916-041 Rib Assembly		Manufactured	No			100	Each	0.0000	2		PD 10.05.07	
											B58357 → ②	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 4/30/2010







Required Date: 5/7/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3916-5  Light Rib		Manufactured	No			100	Each	2.0000	3			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				WA				2				
					57023			2				
D4016-1  Hinge Half, Base		Manufactured	No			100	Each	4.0000	3			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST109				4				
					57611			4				
D4017-7  Rib		Manufactured	No			100	Each	0.0000	1			
D4017-9  Rib		Manufactured	No			100	Each	0.0000	2			
D4020-1  Mesh (350 Basket Long, Base)		Manufactured	No			100	Each	0.0000	1			
D4020-11  End Mesh, Basket		Manufactured	No			100	Each	1.0000	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				WA				1				
					56990			1				

AD 10.05.07
B58360 - (3)

AD 10.05.07
B5832 - (3)

AD 10.05.07
B58133 - (2)

AD 10.05.07
B58134 - (2)

B58712 x1

SAD 10-05-08

SAD 10-05-19

B58136 x2

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 58235



Parent Item: D3913-041



Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/30/2010

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Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D4021-1 Handle Plate		Manufactured	No			100	Each	7.0000	3			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST109				7				
					57086			7				
D4021-5 Blanking Plate		Manufactured	No			150	Each	4.0000	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST109				4				
					57612			4				
D4034-041 Aft Upper Rib Assembly		Manufactured	No			100	Each	4.0000	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				WA				4				
					57988			4				
D4034-043 Fwd Upper Rib Assembly		Manufactured	No			100	Each	4.0000	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				WA				4				
					58040			4				

AD 10.05.07
B58135-73

B58140

2 88 48/05/10

AD 10.05.07
B58141-50

AD 10.05.07
B58142-50

Friday, April 30, 2010 1:00:35 PM

Shop Packet Print

Page 4

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Long Basket Base Assembly, 350

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Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MS20600-AD4W3		Purchased	No			150	Each	1,891.000	2			
Cherry Rivets												

Location	Loc Qty	Loc Code
ST321	1891	
106375	3	
107939	888	
111636	1000	

MS21042L3	Purchased	No			150	Each	1,816.000	6				
Nut												

Location	Loc Qty	Loc Code
ST300	1816	
113537	20	
113644	796	
114523	1000	

NAS1149F0332P	Purchased	No			150	Each	959.0000	12				
WASHER												

Location	Loc Qty	Loc Code
ST275	959	
18057	959	

2 SN 10/05/19

6 SN 10/05/19

12 SN 10/05/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

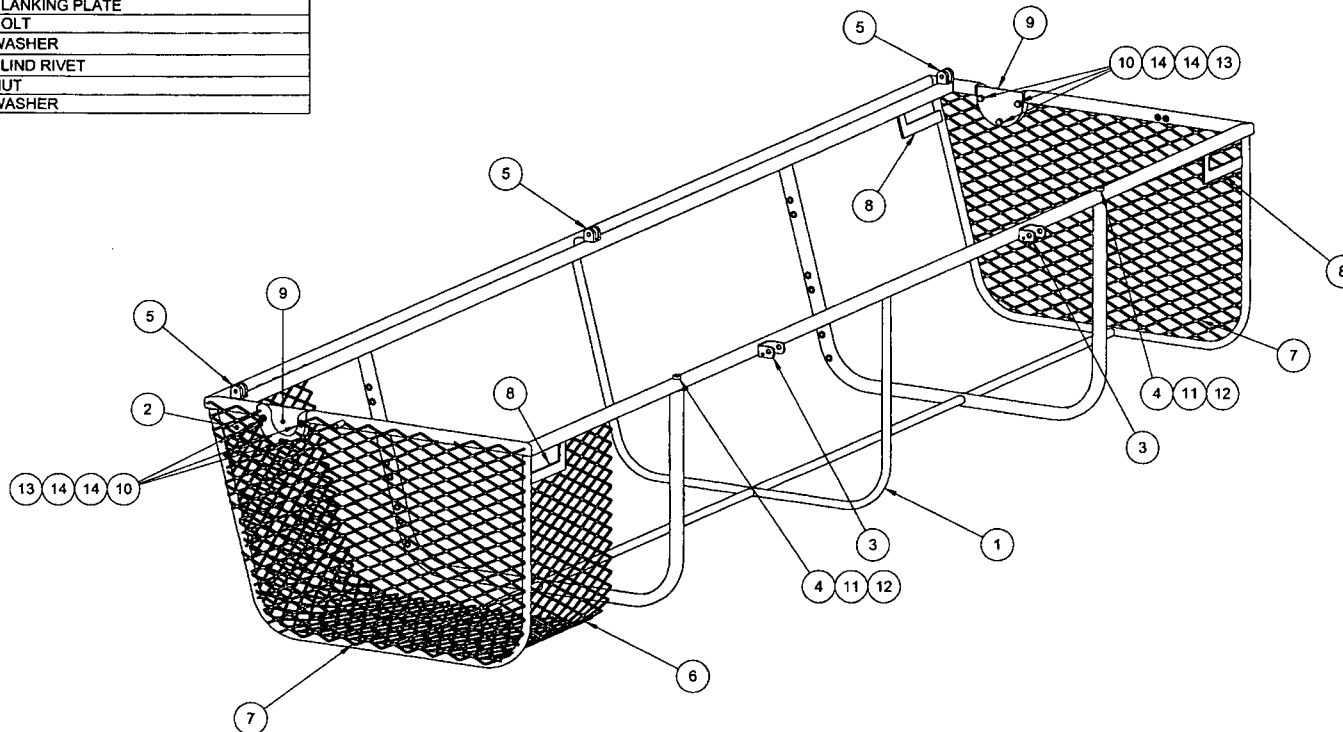
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

RELEASED
2010-03-22
JPH

A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

DETAIL C D7-2

D A7-3
D
D8-2 C
D4020-1
MESH

D3913-101
TUBULAR ASSY

#58235

D2931 BUMPER
AN960JD8 WASHER
MS20600AD4W3 RIVET
2 PL (8)

D2581
MOUNTING BRACKET
2 PL

D4016-1
HINGE HALF, BASE
3 PL

D4021-1
HANDLE PLATE

D4021-1
HANDLE PLATE
2 PL

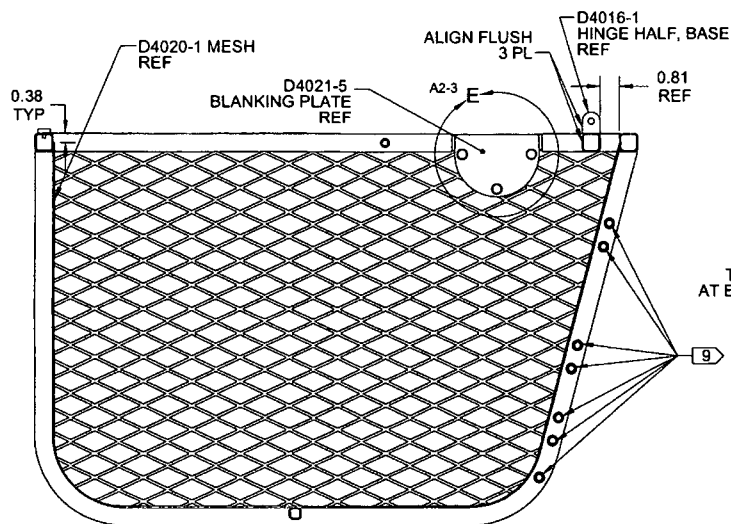
C7-3 A

C3-3 B

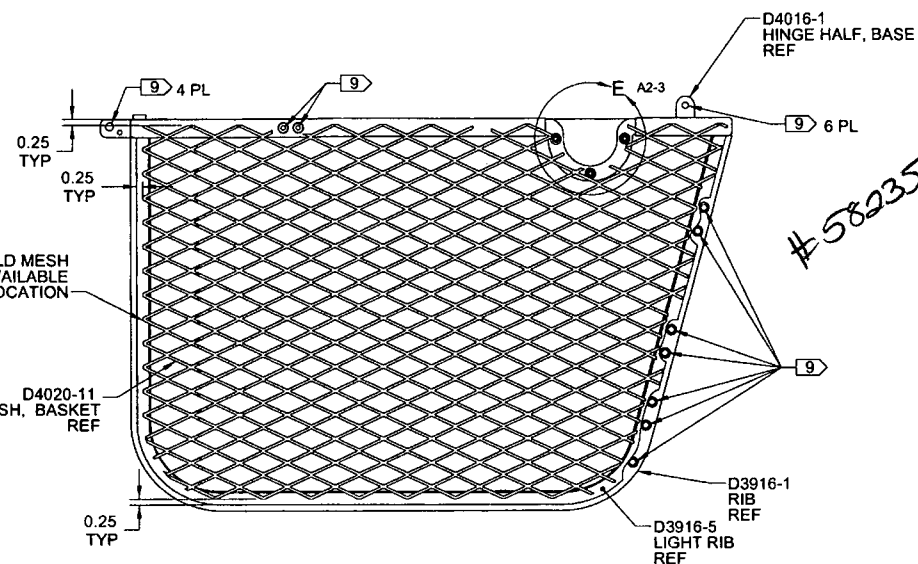
D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-03-27

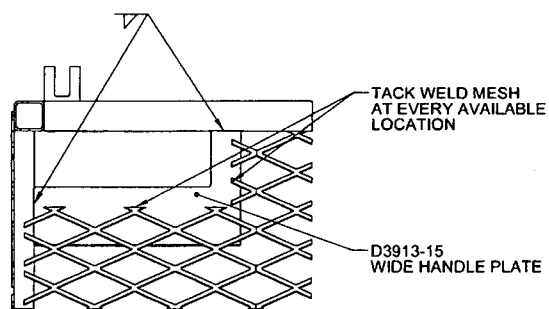
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	AK	D3913	SHEET 2 OF 6
APPROVED	AK	TITLE	SCALE
DE APPR.	AK	LONG BASKET BASE ASSY (350) NTS	
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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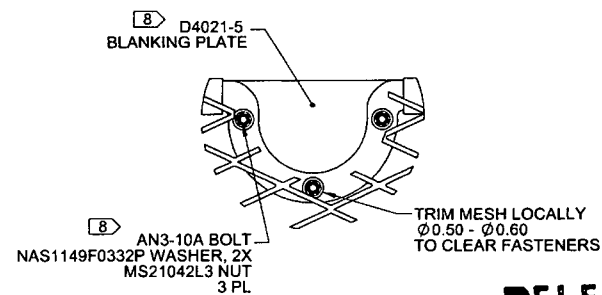
SECTION A-A A5-2



VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES

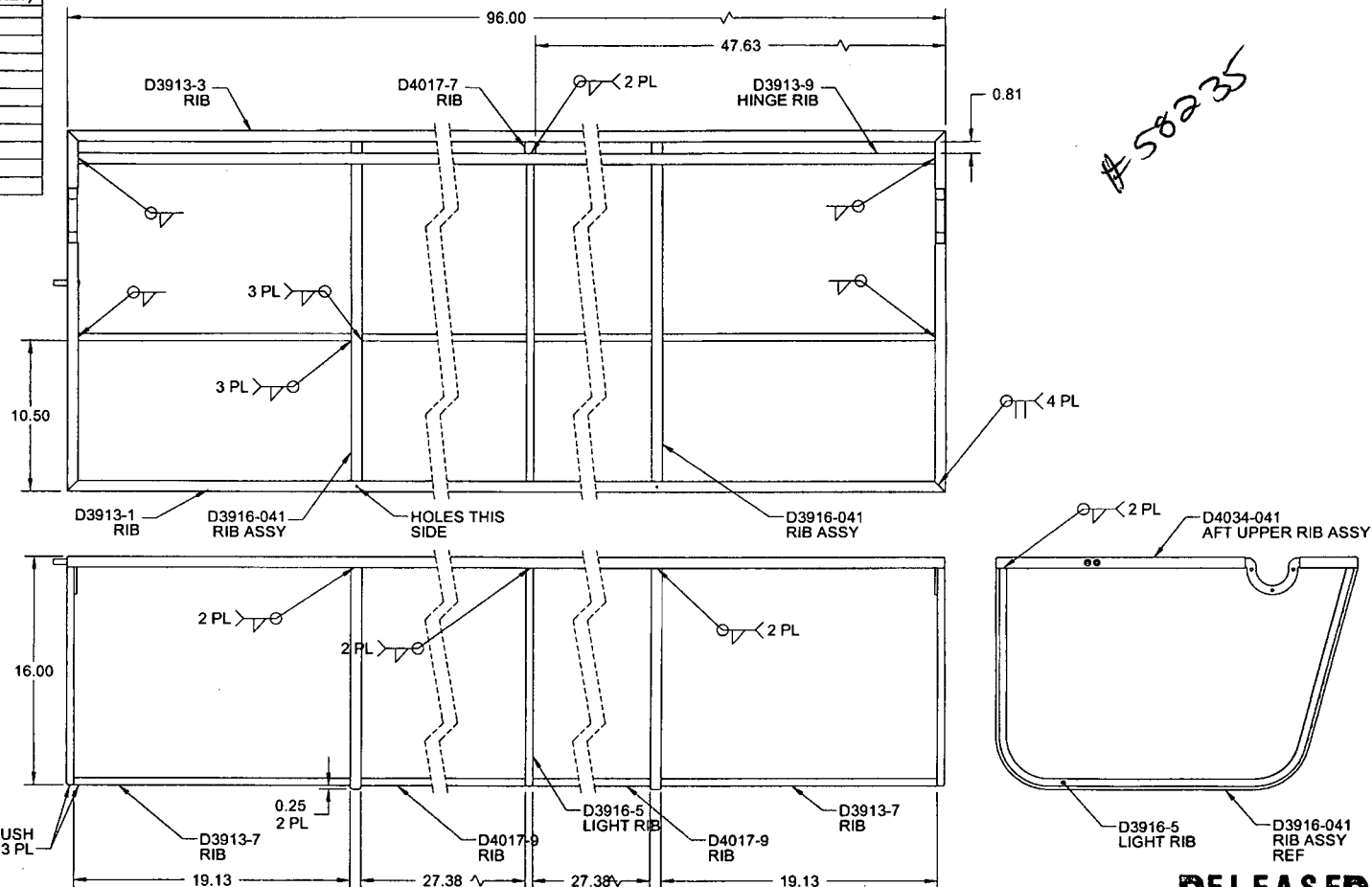


DETAIL E D2-3
D6-3

RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JRH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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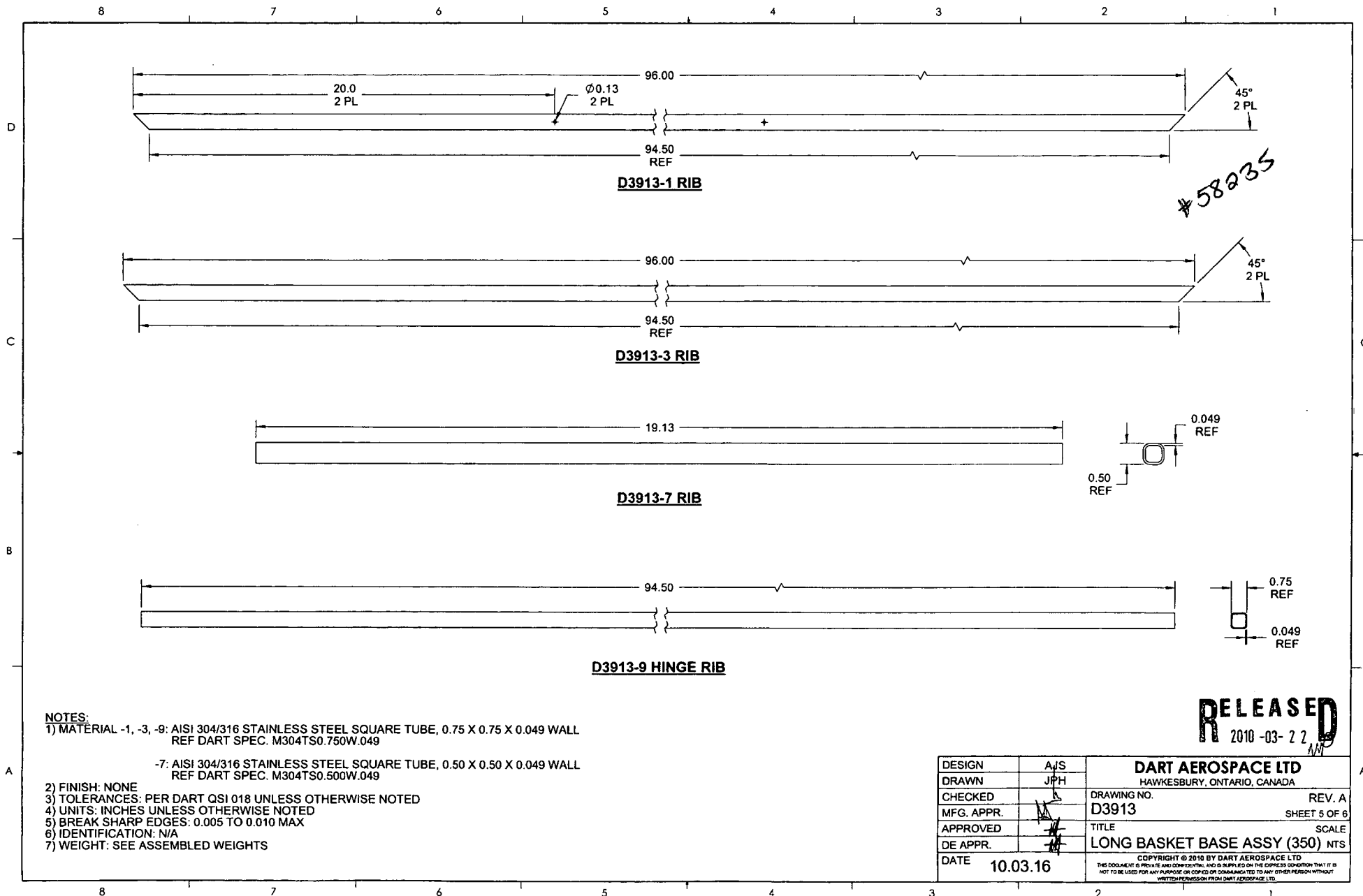
ITEM	QTY	P/N	DESCRIPTION
-101	X		
		D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY

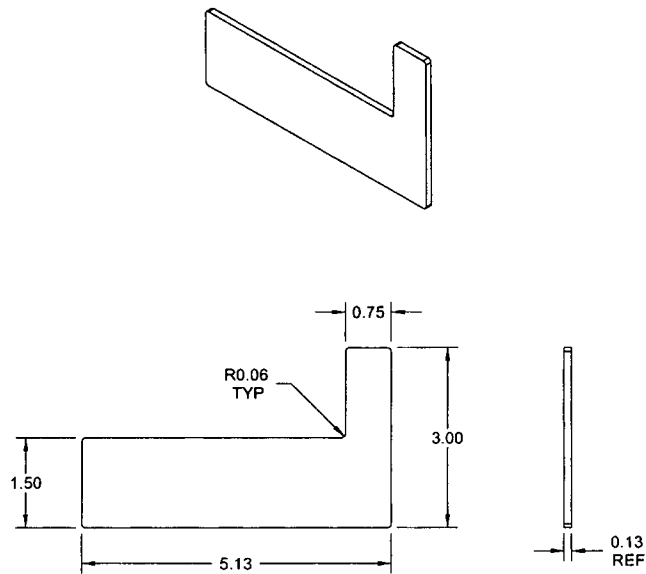


8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 22.53 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ±0.06 FOR D3913-101
 - 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	A	DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JRH		
CHECKED		DRAWING NO. D3913	REV. A
MFG. APPR.			SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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